Memo

Quality Control



Thursday, June 2												
Revision ID:	D3277-1 Window			Accept				s s	Setup S			
Start Date: Required Date: Reference:	6/23/2011 6/28/2011	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item   Customer:					11441111	1 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		R		4		
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp	
Draw Nbr	Rev	ision Nbr				***			-			
D3277	Rev	A										
100 Waterjet FLOW CNC Waterje	et .	FLOW WATER JET  Memo 1-Cut as pe Dwg Rev: Prog Rev: 2-Deburr if	<u></u>	0.00				B11-C	- <u>5</u> 8	(4		
QC Quality Control		QC2- Inspect parts off n	nachine FAI/FAIB	0.00		-		BU	-6-9¢	)		
120 		QC8- Inspect parts - sec	ond check	0.00 E W.	4178			(x4	<u></u>			

					_								
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:					
		esolution:											
NCR: WORK ORDER NON-CONFORMANCE						R)							
DATE	STEP	Description of NC	Corrective Action Section			Verific	cation	Approval	Approval				
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector				
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							•						

#### Work Order ID 71191

Thursday, June 23, 2011 11:20:06 AM



Page 2

Item ID:

D3277-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

**Required Date: 6/28/2011** 

Window

6/23/2011

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

4 -	nra	vole.
AD	DFO	vals:

Process Plan:

Date:\_

Tooling: SPC (Y/N): Date:

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID** 

Operation **Description**  Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Oty

Reject Qty

Reject Insp. Number

Stamp

125

Small Fab

Small Fab

Memo

ENGRAVE P/N AND B/N AS PER DWG

Date: \_\_\_\_\_

0.00

0.00

130

Quality Control

QC6- Inspect dimensions to drawing

Memo

Identify as per dwg & Stock Location:

0.00

Packaging

0.00

Packaging

140

Memo

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·					,		٠
							<u> </u>		<u> </u>
Part No	·	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:						Date: _	
NCR: WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC				Verific	cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
		·							
							-		

#### Work Order ID 71191

Thursday, June 23, 2011 11:20:06 AM



Page 3

Item ID:

D3277-1

Accept

Setup Start

**Revision ID:** 

Window Item Name:

Required Date: 6/28/2011

QC:

6/23/2011

Start Qty: 4.00

**Req'd Qty:** 4.00



**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

**Approvals:** 

Process Plan:

Date:

Date:

**Tooling:** SPC (Y/N): Date: Date: Run

Start

Stop

Stop



Sequence ID/

**Work Center ID** 

150

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan

Accept

Reject

Reject Insp. Number

Memo

0.00

Code

Qty

Qty

Stamp

Quality Control

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CH	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR: WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC			Veritica				Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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#### **Picklist Print**

Thursday, June 23, 2011 11:20:03 AM

Work Order ID: 71191

Parent Item: D3277-1

Parent Item Name: Window



Start Date: 6/23/2011

Start Qty: 4.00

Required Date: 6/28/2011

Page 1

Required Qty: 4.00

<b>Comments:</b>	

IPP A□05.03.22□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	-	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	287.4934	5.174	21.78526	221	99	
				<b>Location</b>		Loc (	<u>Oty</u>	Loc Code				14	
				MAT		142.	2467		_			$\bigcup$	
					117431	142.	2467		<del></del>				
				MAT018		142.	2467		_				
					117324	68.	7667		<u>1</u>	17324	ΧZ		
					117340	7	73.48		1	<u>い ¾ሪ`</u>	× 2		
				MAT019			3						
					115338		3		_				

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W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					2							
Part No	<b>:</b>	PAR #:	Fault Cate	gory: :	NCR: Ye	s No Do	QA:	Date: _				
	Res	solution:	Dispositio	n:	QA: N/C	Closed: _		Date: _				
NCR:			WORK ORD	ER NON-CONFORM	IANCE (N	CR)						
DATE	STEP	Description of NC			ection B	Veri	fication	Approval	Approval			
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		ction C	Chief Eng	QC Inspector			
					,							

DART AEROSPACE LTD	Work Order:	ll I
Description: Crew Window	Part Number:	D3277-1
Inspection Dwg: D3277 Rev: A	<del>                                     </del>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST											
		X First Arti	cle	Prot	otype						
Drawing	Tolerance	Actual	Accept	Reject	Method of		omments				
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	)	omments				
0.125	+/-0.010	.124	72		V But						
22.86	+/-0.030	એ .શ્રે	7		7						
32.34	+/-0.030	30.34	7 3 12 1		7						
						!					
						1					
				1417.02	•						
							-				
						f					
Measured by:	B	Audited by:	8		Prototype A	Approval:	N/A				
Date:	11-6-28	Date:	World	8		Date:	N/A				
Rev Date	Change			·····		Revised by	Approved				
A 08.10.07	New Issue		-			Revised by	Approved				

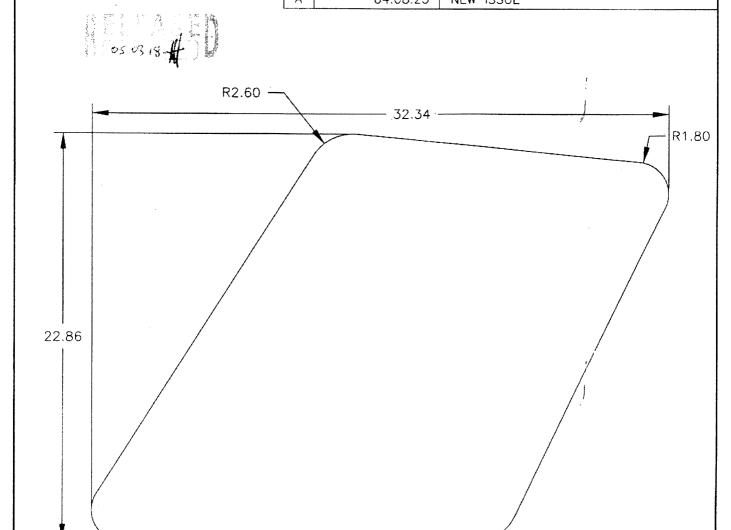
Rev	Date	Change	Revised by Approved
Α	08.10.07	New Issue	KJ/DD 🖈

Dail Aci	ospace	, Ltd									
W/O:			WORK ORDER CHANGES								
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								*			
Part No	:	PAR #:	Fault Category: NC			No <b>DQ</b>	A:	Date:			
the control of the c			Disposition: Q								
NCR:	÷	W	ORK OR	DER NON-CONFORMAN	NCE (NCI	R)					
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval		
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Secti		Chief Eng	QC Inspector		
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DESIGN (A)		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHEC	(ED A	APPROVED #	DRAWING NO. D3277	REV. A SHEET 1 OF 1			
DATE			TITLE	SCALE			
04.08.23			CREW WINDOW (R44)	1:5			
Δ		04 08 23	NEW ISSUE				

- R2.60



R1.72

- D3277-1 WINDOW

  1) CUT PER TEMPLATE D3277-1T1
- 2) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGRAVE P/N & B/N

ON LOWER EDGE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005"

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W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·									
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes No DQA:			_ Date: _	
	R	esolution:	Disposition:			\: N/C Closed:			
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section			Verification		Approval	Approval
DAIL	JILI		Initial Chief Eng	Action Description Chief Eng	Sign Date		ion °C	Chief Eng	QC Inspector
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H;\fFORMS\Quality Assurance\approved QA\NCRWO RevE